

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019722**Date Inspected:** 11-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG 13 & 14**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Mr. Wai Pau was present during the times noted above for observations relative to the work being performed.

Shielded Metal Arc Welding (SMAW) repair weld process in the 2G and 3G position of the floor beam (FB) components of lift 14W. The welder is identified as 066398, 066038, 067520, 047864, 201215, 066734, 068445, 066695 and 045175. The weld designation is SEG3020AA-024, SEG3020X-013/014, SEG3020Q-058, SEG3020X-010/011/012 and SEG3020-077. ZPMC QC identified as ZPMC QC Mr. Li Ming Yang, Wang Jie and Wang Chao. The welding variables recorded by QC appeared to comply with Caltrans approved CWR2657, 2662, 2670, 2659, 2653.

Flux Cored Arc Welding (FCAW) process in the 2G and 3G position of the floor beam (FB) and longitudinal diaphragm (LD) components of lift 14W. The welder is identified as # 068445, 066695 and 045175. The weld designation is SEG3020BB-028/029 and SEG3020X-008. ZPMC QC identified as ZPMC QC Mr. Li Ming Yang, Wang Jie and Wang Chao. The welding variables recorded by QC appeared to comply with Caltrans approved WPS -B-T-2132-EASB and WPS -B-T-2133-EASB.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

**Summary of Conversations:**

As notes within report above

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for

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## WELDING INSPECTION REPORT

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your project.

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<b>Inspected By:</b>	Pau, Wai	Quality Assurance Inspector
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<b>Reviewed By:</b>	Patterson, Rodney	QA Reviewer
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